Dart Aerospace Ltd. Wednesday, 6/6/2007 2:02:45 PM ÍUser **Process Sheet Drawing Name** : FRAME : CU-DAR001 Dart Helicopters Services Customer Job Number : 32816A Estimate Number : D32241 Part Number P.O. Number · D3224 REV A **Drawing Number** · : 6/6/2007 This Issue : NC ** Project Number : N/A Prsht Rev. → : A · MACHINED PARTS **Drawing Revision** First Issue Material : 32272A Previous Run . **Due Date** : 6/20/2007 8 Um: Each Written By Checked & Approved By 05-11-06 JLM Comment Est: B 06.11.15 EC waterjet **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 2024-T3 .063 sheet M2024T3S063 1.0 SAD 07/08/02 5.4600 sf(s)/Unit Total: Comment: Qty.: 43.6800 sf(s) B# M104921 2024-T3 .063 thick aluminumsheet Batch: Most 1 WATER JE 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D3224 Dwg Rev:_ Prog Rev:_ 2-Deburr if necessary 3.0 QC2 PARTS AS THEY COME OFF MACHINE SECOND CHECK QC8 4.0

Comment: SECOND CHECK
0 SMALL FAB 1

Deburr

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

CAD

09/08/09



5.0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
0706											

Part No: D3224 - 1	_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	÷	•	QA: N/C C	losed:	Date:

NCR: 32	28164	W	ORK OR	DER NON-CONFORMANC	E (NCR)			
DATE	STEP	Description of NC Section A	Section A Initial Action Description Sign &			Verification Section C	Approval Chief Eng	Approval QC Inspector
0706-16	2.0	wrong grain direction Scap 2 parts	asim2	Replace the 2 parts cles tray	07 06 18	60-06-18	Posiun	1506-18
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	:							

NOTE: Date & initial all entries

Date: We	dnesday, 6/6/2007 2:02:45 PM			
User: Kin	n Johnston	Process Sheet		
r Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name: FRAME	· · · · · · · · · · · · · · · · · · ·	· ·
	, , , , , , , , , , , , , , , , , , , ,	_		•
Job Number	· 32816A	Part Number: D32241		
Job Number:	CARRIED HILL BLANCE HELE BURNING HELD			
Job Nullibel.				
	[<u></u>	
Seq. #:	Machine Or Operation:	Description :		
6.0	BRAKE NC	NC BRAKE		
Comm	ent: NC BRAKE		<u> </u>	1 / 1 —
	Form as per Dwg D3224		85 57	10/5
7.0	QC5	INSPECT WORK TO CURRENT STEP	5 1003 (0 1012) (1014 (011 160)	conter
				i outer
	<u> </u>	-		
	ent: INSPECT WORK TO CURRENT STEP	The state of the s	07/10/65	(8)
. 8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	1 1 0 0 1 11 11 10 10 11 10 1 10 1 1	
Comm	ent: HAND FINISHING RESOURCE #1		1 01/0	
	Chemical Conversion Coat as per QSI (VEDOUGH ON THE	1100
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CON	IVERSION / / /	
		<i>/</i> 2 /		
		CONTRIBUTION AND AND AND AND AND AND AND AND AND AN	MINIMUM MAIN	
	ent: INSPECT POWDER COAT/CHEMICAL	PACKAGING RESOURCE #1	// 5 ()	······································
10.0	PACKAGING 1	PACKAGING RESOURCE #1		
Comm	ent: PACKAGING RESOURCE #1		\$ M	
Johns	Identify and Stock		[.]	
	Location:	1/10/12 (8)		
11.0	QC21	FINAL INSPECTION/WO RELEASE		10
\				07.10.14
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Comm	ent: FINAL INSPECTION/W/O RELEASE			'4
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Job Completion			1 84.10.1	6
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Form: mrocess

Page 2

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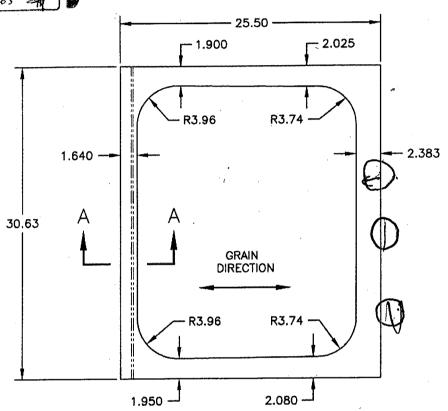
W/O: WOI			WORK ORDER	ORK ORDER CHANGES						
DATE	STEP		PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							·			
				•						
Part No);	. ,	PAR #:	Fault Category:	NCR: `	Yes	No DQA	\ :	_ Date: _	
					C	A: N	I/C Closed	l:	_ Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section I	3	Verification	A	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto			
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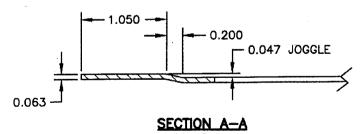
NOTE: Date & initial all entries



DESIGN	DRAWN BY		ROSPACE LTD y, ontario, canada
CHECKED 1	APPROVED	DRAWING NO.	REV. A
#	- 4	D3224	SHEET 1 OF 1
DATE		TITLE	SCALE
03.10.2	1	FRAME	etin
Α	03.10.21	NEW ISSUE	



D3224-1



SCALE 8:1

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY

2) MATERIAL: 2024—T3 (QQ—A—250/4), 0.063 THICK (REF. M2024T3S.063) UBJECT TO AMENDMENT.
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
4) ALL DIMENSIONS ARE IN INCHES

4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	32816A
Description: Frame	Part Number:	D3224-1
Inspection Dwg: D3224 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Arti	cle	Prot	otype
	Actual			Method

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
25.50	+/-0.030	25.50	/		M-T	
30.63	+/-0.030	30.60-	- · - V-		HT	= = = = = = = = = = = = = = = = =
1.900	+/-0.010	1,910	/		Vern	
2.025	+/-0.010	2.029			Vern	
1.640	+/-0.010	4.650	/	/	Vern	
1.950	+/-0.010	1.960			Vern	',
2.080	+/-0.010	2,083			Vern	
0.063	+/-0.010	0.067			Ven	
2.383	+/-0.010	2, 393	/		Ven	
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Meas	ured by:	SAO	Audited by:	Prototype Approval:	N/A
	Date:	27-143-130	Date: 07/08/03	Date:	N/A
		07/08/02			
Rev	Date	Change		Revised by	Approved
Α	04.10.05	New Issue >	P/O D412-709-011	KJ/JLM 🚓	- Chil